

Work Order ID 87024***87024***

Page 1

Monday, July 09, 2012 9:17:05 PM

Item ID: D4522-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base, Vertical Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4522	B
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100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK AT 1.875"

0.00

B.D 12/07/10

2 0

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER DWG & FOLIO FB105

FOLIO REV: AN
DWG REV: 25

0.00

29 12 7 12

2 0

DEBURR

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

29 12.7.12

2 4

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DA
14
2.8

12/07/16

2 4

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2 24 12-7-16

13.

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Setup Start

NS1

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Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

DAS
30
12/07/17

160

0.00

160

Small Fab

Memo

0.00

Small Fab

INSERT HELI-COIL

(2)

Ø

FF
12-07-17

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
8-83

12/07/17

(42)

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Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Identify as per dwg & Stock Location: ST 117 0.00***180***

Packaging

Memo

0.00

Packaging

2xSP
12-7-17

190

QC21 - Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

12/7/19MF
12-07-18

Picklist Print

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Page 1

Work Order ID: 87024
Parent Item: D4522-047
Parent Item Name: Base, Vertical Swing Arm

Start Date: 7/10/2012
Start Qty: 2.00

Required Date: 7/19/2012
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-18 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.250 6061-T6 Bar 2.00 x 1.25		Purchased	No				f	46.8001		0.332		B.A 12/07/10	

Location	Loc Qty	Loc Code
MAT009	10.8	
→ 121660	10.8	
MAT010	36.00006358	
121040	0.00006358	
122321	36	

MS21209-C0820
Threaded Insert, 8-32 UNC x 0.33 LG

Purchased No

Each 10.0000

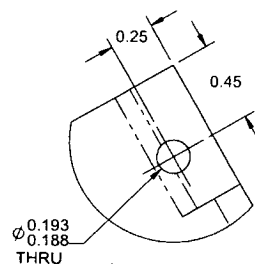
Location	Loc Qty	Loc Code
ST305	10	
120593	10	

0.332 ft

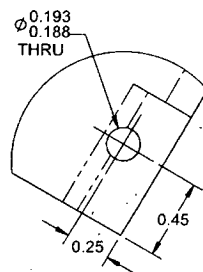
4 Jul 12-07-16
② FF 12-07-17

24

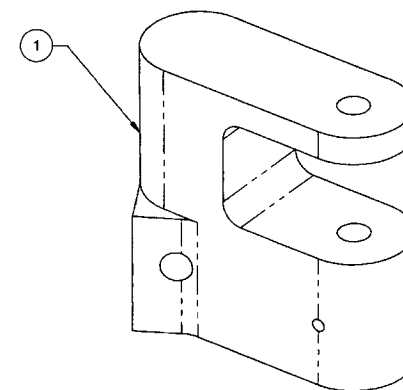
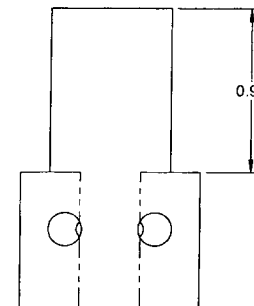
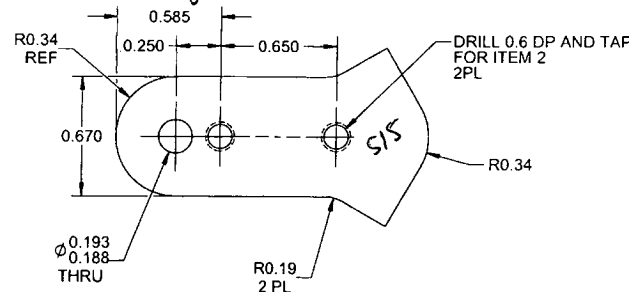
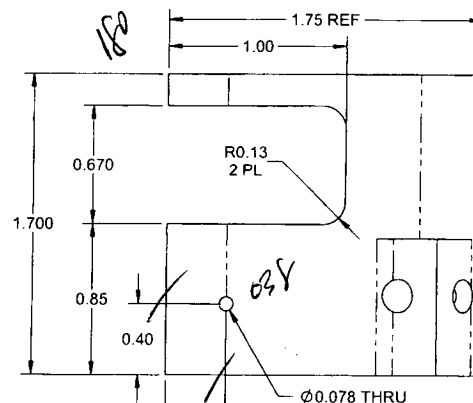
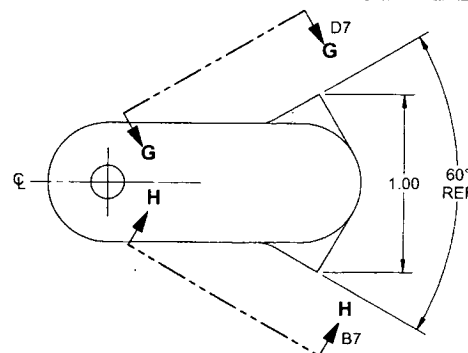
ITEM	QTY	P/N	DESCRIPTION
	X	D4522-047	BASE, VERTICAL SWING ARM
1	1	D4522-5	BASE, VERTICAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



VIEW G-G D4



VIEW H-H C4



- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
 - 7) WEIGHT: 0.14 lbs

D4522-047 BASE, VERTICAL SWING ARM

RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 10 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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174/2 = 87
187/2 = 93.5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

